

Work Order ID 56161

February 11, 2010 2:46:51 PM



Page 1

Item ID: D4042-043

Accept



Setup Start



Revision ID:

Item Name: Aft Rib Assembly

Stop



Start Date: 2/11/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/19/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date: 10-2-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4042	PAN
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100



Weld per dwg A/R S.S. rod Batch: M109213

0.00

Large Fab

Memo

0.00

- / 1- Cut as per dwg D4042-3
- / 2- Drill and chamfer holes as per dwg D4042-3
- / 3-remove identification markings
- / 4- Weld bushing in rib and grind weld flush as per dwg D4043

110



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56161

Page 2

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Cust Item ID:

Required Date: 2/19/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC10- Inspect visual per QSI004- ground welds

0.00

8/10/02 1:17

0.00

(X)



QC

Memo

Quality Control

130

Identify as per dwg & Stock Location: basket 0.00

0.00

PD 10.02.19



Packaging

Memo

Packaging

140

QC21- Final Inspection - Work Order Release 0.00

0.00

0.00

10/02/25 (J)



QC

Memo

Quality Control

~~POSITIVE RECALL~~
~~EFFECTIVE 10/2/11~~
~~RELEASED 10/2/19~~
~~DATE 10/2/19~~

MF
10-2-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

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Work Order ID: 56161



Parent Item: D4042-043



Parent Item Name: Aft Rib Assembly

Start Date: 2/11/10

Required Date: 2/19/10

Comments: IPP RevA: new issue DD 10.01.07 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D4021-9 		Manufactured	No			100	Each	0.0000	2.0000	B56094 → ②	<i>lpl</i> 10-02-17	
Bushing M304TS0.750W.049 		Purchased	No			100	f	273.8661	2.1491		<i>lpl</i> 10-02-17	
304 SQ Tube .75x.75x.049W												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	273.8661	
103240	1.5816	
106604	4.9307	
107460	29.2779	
113763	238.0759	

1 ① lpl

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

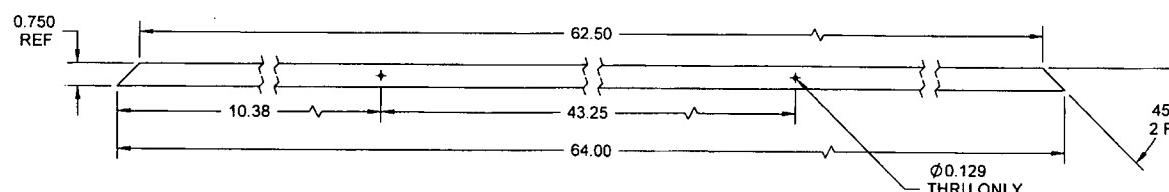
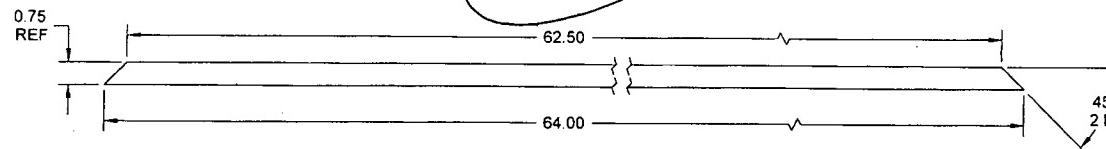
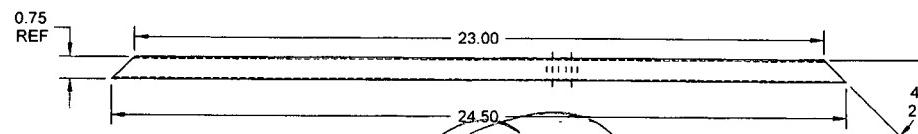
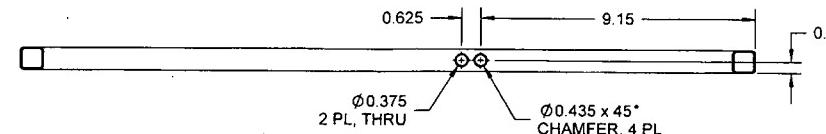
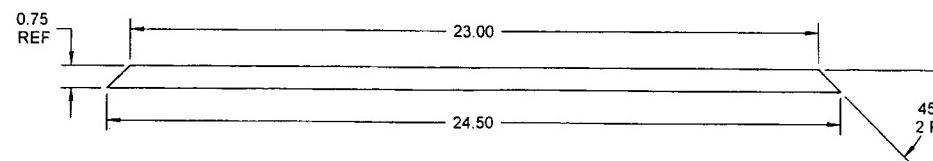
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



W
S6601

RELEASED
2010-02-16
JNP

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 x 0.75 x 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4042-1: 0.89 lbs
D4042-3: 0.88 lbs
D4042-5: 2.36 lbs
D4042-7: 2.36 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	QO	REV. A	
MFG. APPR.	JK	DRAWING NO.	D4042
APPROVED	JK	TITLE	SHORT BASKET BASE ASSY
DE APPR.	JK	SCALE	NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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ITEM	QTY -043	P/N	DESCRIPTION
	X	D4042-043	RIB AFT ASSEMBLY
1	1	D4042-3	AFT RIB
2	2	D4021-9	BUSHING

D

D

C

C

B

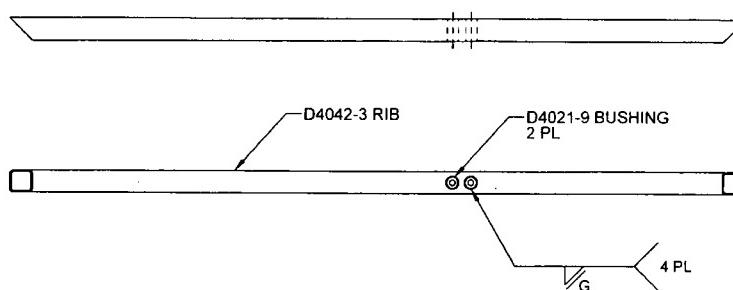
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A

A

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.91 lbs
- 8) WELD PER DART QSI 004

D4042-043 AFT RIB ASSEMBLY

RELEASED
R 2010-02-16
MP

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>Q</i>	REV. A	
MFG. APPR.	<i>RS</i>	DRAWING NO.	
APPROVED	<i>MP</i>	SHEET 9 OF 11	
DE APPR.	<i>MP</i>	TITLE	SCALE
DATE	10.01.29	SHORT BASKET BASE ASSY	

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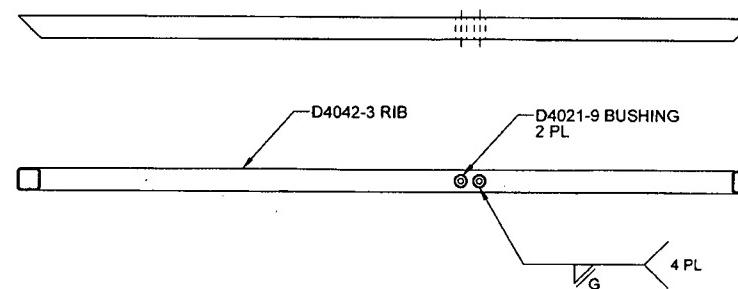
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D

D

D4042-043 AFT RIB ASSEMBLY

8

B

A

NOTES:

- 1) MATERIAL: N/A
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A

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DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	R	DRAWING NO.
MFG. APPR.	R	D4042
APPROVED	R	SHEET 9 OF 11
DE APPR.	R	TITLE
DATE 10.01.29		SCALE
		NTS

RELEASED
2010-02-16
MP

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